

Date: Wednesday, 5/16/2007 1:42:36 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 32412	
Estimate Number : 12729	
P.O. Number : N/A	Part Number : D353539
This Issue : 5/16/2007 S.O. No. : N/A	Drawing Number : D3535-UNDER REVIEW 07.05.17
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30752	Material : N/A
Written By : <u>07.05.16</u>	Due Date : 5/31/2007 Qty: 16 Um: Each
Checked & Approved By : <u>07.05.16</u>	
Comment : Est Rev.A New Issue 07-02-15 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.9986 sf(s)/Unit Total : 15.9768 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M101873

MA 07.05.25

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

SAD 07/05/26 16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/26 16

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07.05.28 (16)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

Form Joggle on brake using Jig DT8158 as per Dwg D3535

SB 07/06/13 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PL Date: 07/06/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:42:36 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32412

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* En 07/06/22 (16) *counted*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*Handwritten:* M101601

*Handwritten:* BR/M 07-06-21

*Handwritten:* (16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*Handwritten:* Fd 07/06/22

*Handwritten:* (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*Handwritten:* F-P-16

*Handwritten:* M-L 07/06/22

*Handwritten:* (16X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* Fd 07/06/22

*Handwritten:* (16)

Job Completion



*Handwritten:* U 07/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

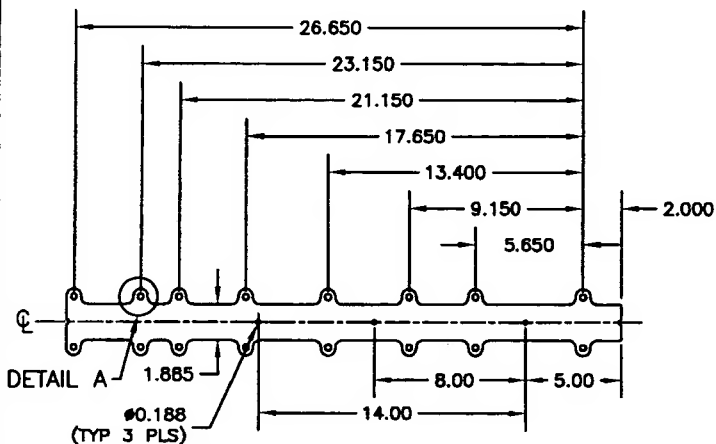
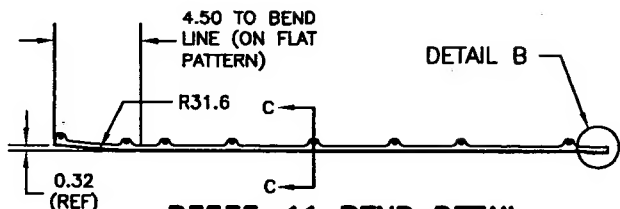
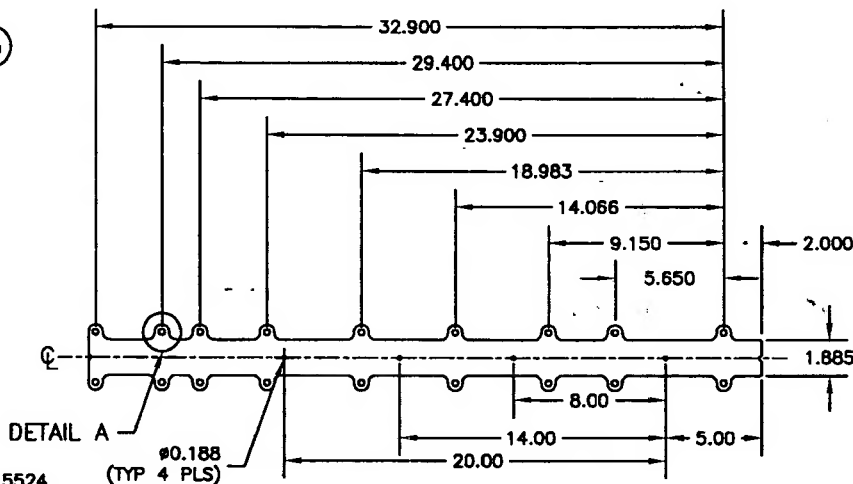
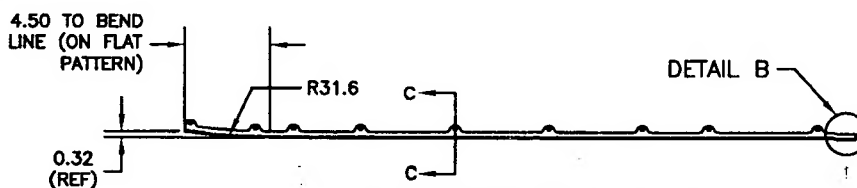
**DART**

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07.04.24

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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

1:10

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\bar{C}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

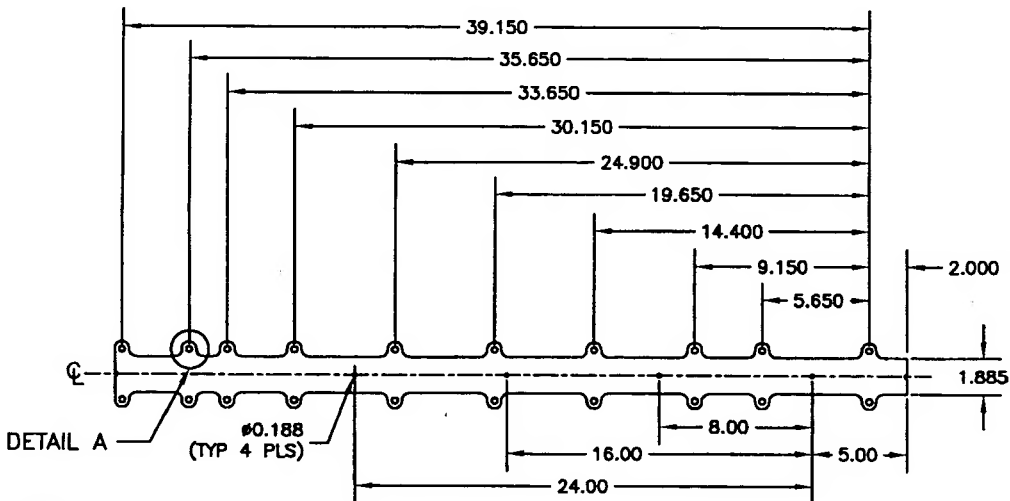
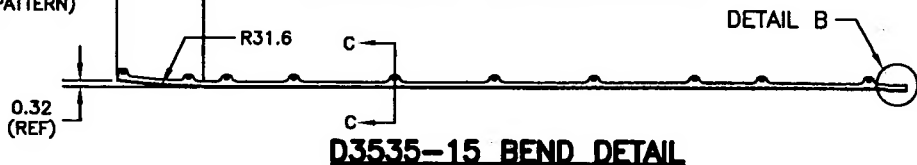
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WITHOUT NOTICE  
WORK ORDER  
NO. 32412

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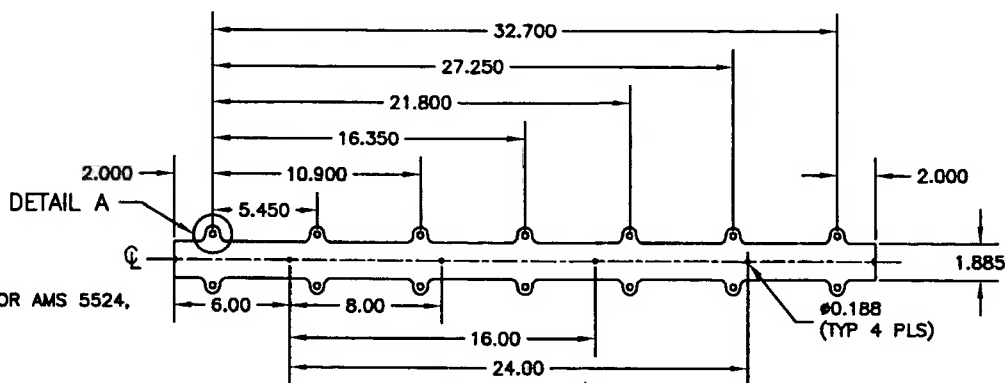
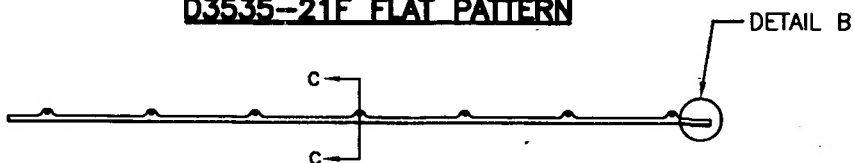
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<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REVISION
07.04.17	WEARSHOE	SHEET 2 OF 7
		SCALE
		1:10

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

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**NOTES**

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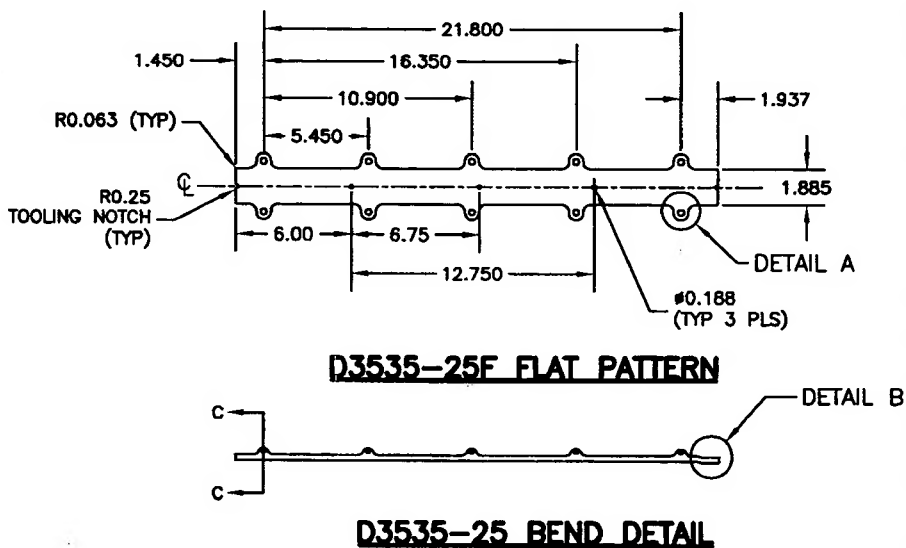
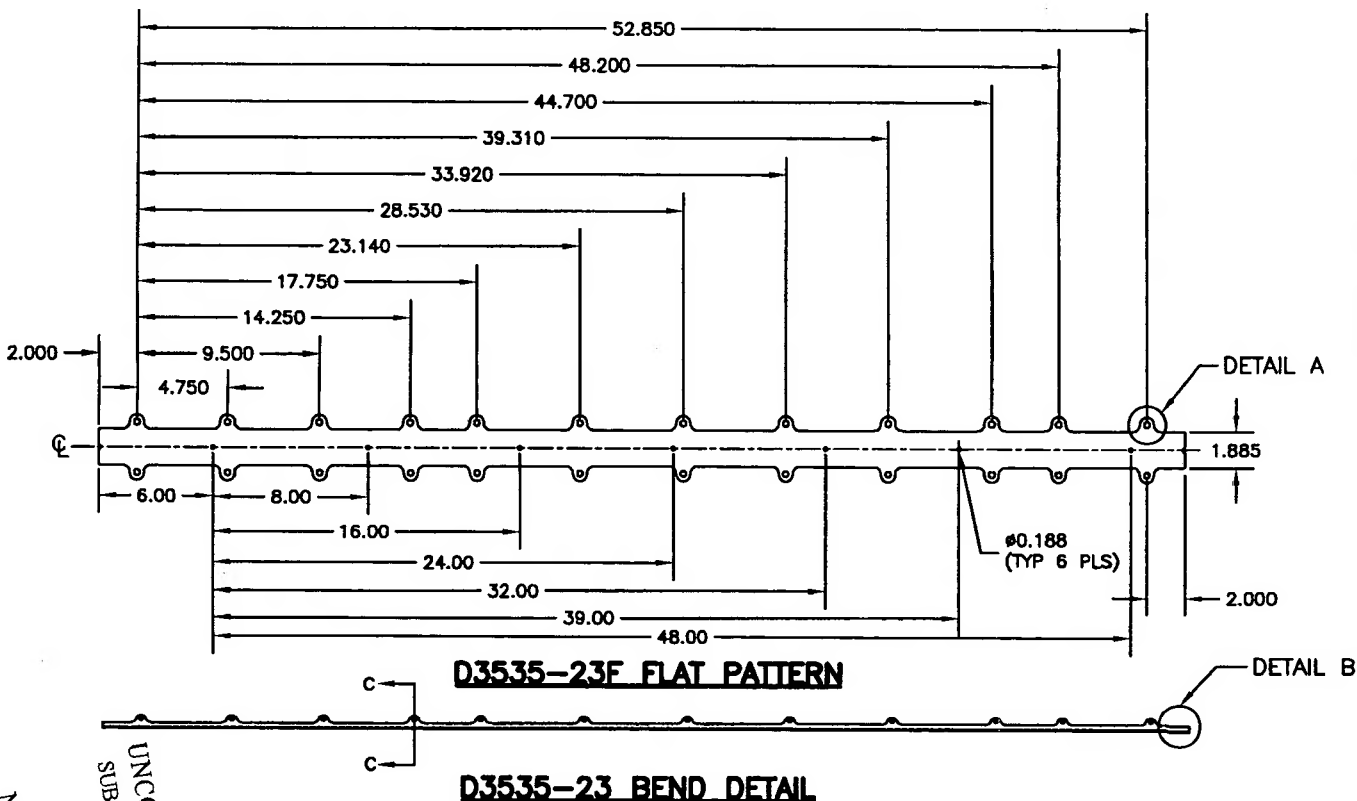
**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

**DART**

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#	#	D3535	SHEET 3 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

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07.04.24



**NOTES**

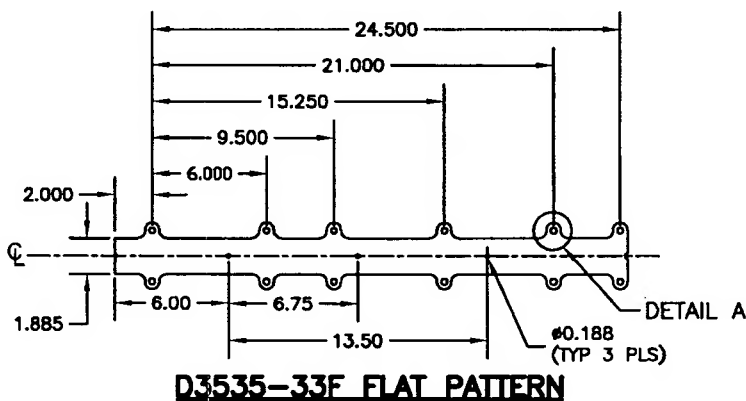
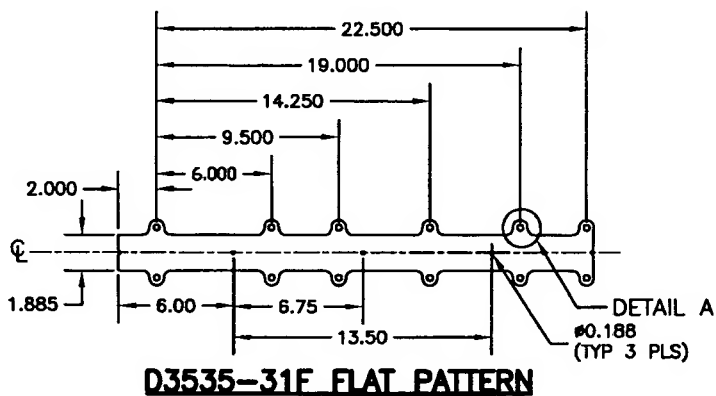
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DATE	07.04.17	TITLE	D3535	REAR SHOE
				WEARSHOE
				SCALE 1:10
				SHEET 4 OF 7

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**NOTES**

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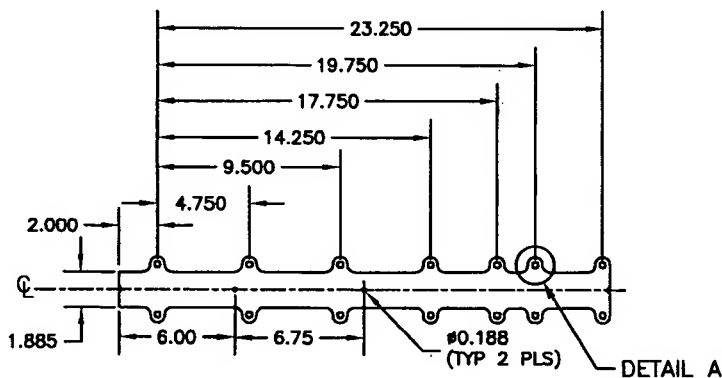


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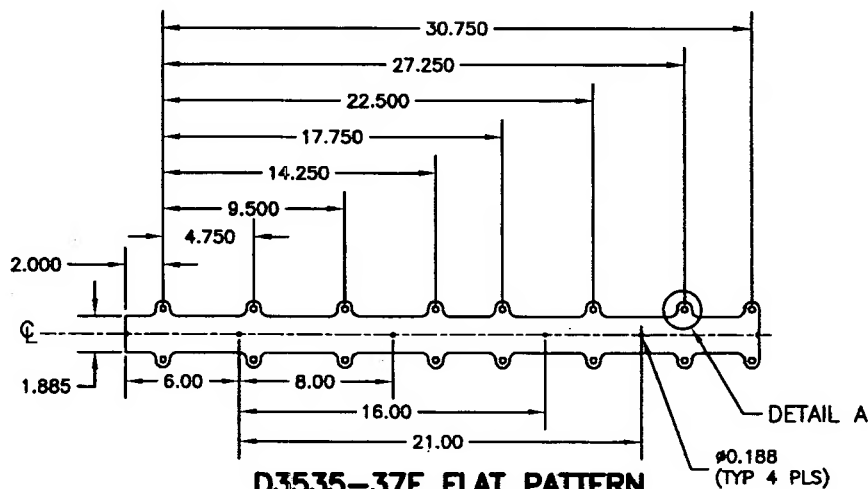
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

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**NOTES**

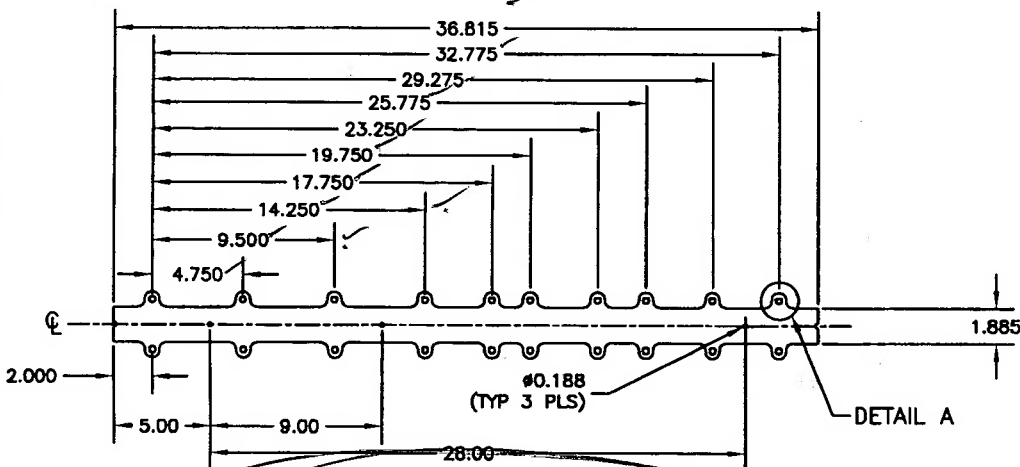
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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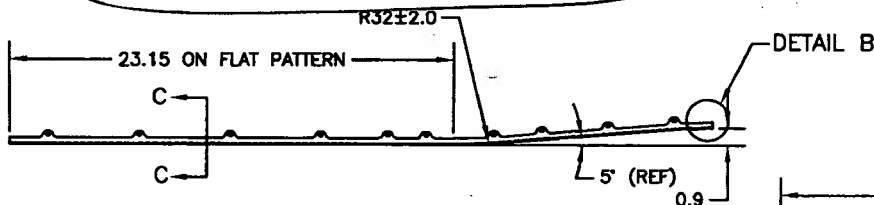
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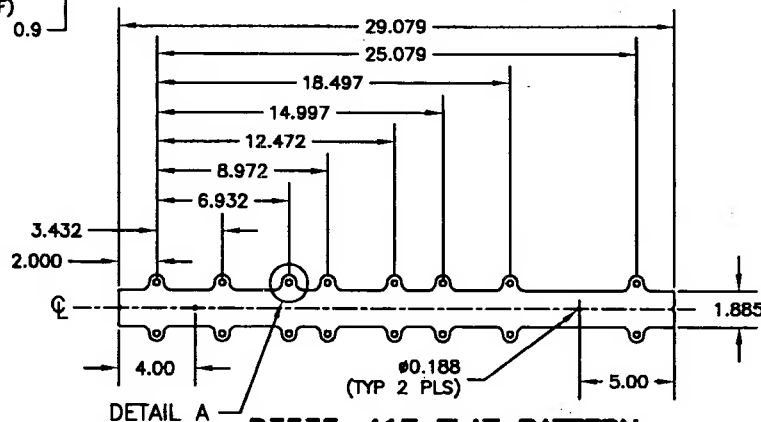
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
				SCALE 1:10



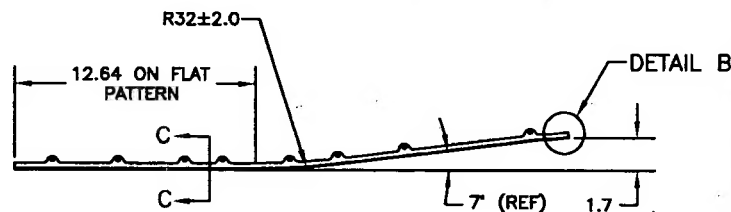
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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WORK ORDER  
32412

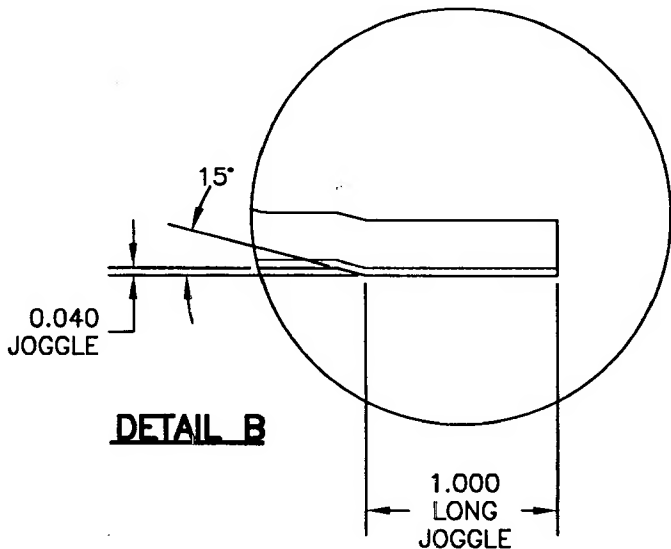
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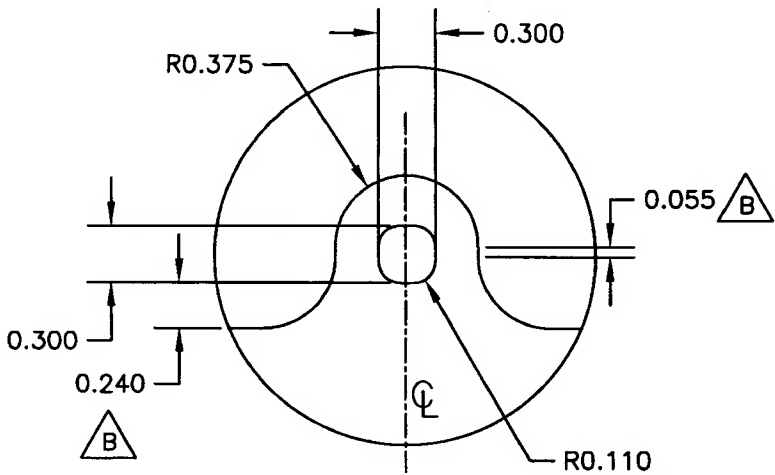


DESIGN	C.B.	DRAWN BY	A.H.	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
		SCALE	1:1	

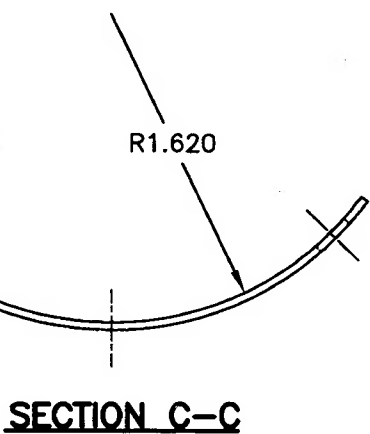
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DETAIL B



DETAIL A



SECTION C-C

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WORK ORDER  
NO. 32412

DART AEROSPACE LTD		Work Order:	32412
Description: <del>BEARING</del> WEARSHOE		Part Number:	D353539
Inspection Dwg: D3535 Rev: AB		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.000	+/- 0.010	2.000	✓		height gage	
B 5.00	+/- 0.030	5.001	✓		height gage	
C 9.00	+/- 0.030	9.006	✓		Vern	
D 28.00	+/- 0.030	28.00	✓		Vern	
E 1.895	+/- 0.010	1.895	✓		Vern	
F 4.750	+/- 0.010	4.759	✓		Vern	
G 9.500	+/- 0.010	9.503	✓		Vern	
H 17.250	+/- 0.010	17.250	✓		M-T	
I 17.750	+/- 0.010	17.750	✓		M-T	
J 19.750	+/- 0.010	19.750	✓		M-T	
K 23.250	+/- 0.010	23.250	✓		M-T	
L 25.775	+/- 0.010	25.775	✓		M-T/Vern 2	
M 29.275	+/- 0.010	29.275	✓		M-T/Vern 2	
N 32.775	+/- 0.010	32.775	✓		M-T	
O 36.815	+/- 0.010	36.815	✓		M-T	
P 0.188	+0.005/-0.001	0.190	✓		Vern	
Q 0.300	+/- 0.010	0.300	✓		Vern	
R 0.300	+/- 0.010	0.300	✓		Vern	
S 0.038	+/- 0.010	0.035	✓		Vern	
T						
U						
V						
W						
X						
Y						

Measured by: <u>SM</u>	Audited by: <u>[Signature]</u>	Prototype Approval:	N/A
Date: <u>07/05/26</u>	Date: <u>1905-28</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

[Signature]